



**Work Order ID 102091**

Thursday, May 23, 2013 3:29:44 PM

**\*102091\***

Page 2

Item ID: D3179-041

Accept

Revision ID: U/R

Item Name: Fwd Litter Tie Down

Start Date: 5/30/2013 Start Qty: 8.00

**\*8\***

Required Date: 5/30/2013 Req'd Qty: 8.00

**\*8\***

Reference:

**\*N900040100\***

Setup Start

**\*NS1\***

Stop

**\*NS2\***

Cust Item ID:

Customer:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***Sequence ID/  
Work Center ID

130

**\*130\***

QC

Quality Control

Operation  
Description

QC8- Inspect parts - second check

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

13-6-3

8

DAS  
04  
8-83

140

**\*140\***

HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

8 NG13-6-5

Memo

0.00

150

**\*150\***

QC

Quality Control

QC8 Inspect Part Finish

0.00

Memo

0.00

8X Ø mf 13/06/05

**Work Order ID 102091**

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**\*102091\***

Page 3

**Item ID:** D3179-041

Accept

**Revision ID:** U/R

**\*N900040100\***

Setup Start

**\*NS1\***

**Item Name:** Fwd Litter Tie Down

Stop

**\*NS2\***

**Start Date:** 5/30/2013 **Start Qty:** 8.00

**\*8\***

**Required Date:** 5/30/2013 **Req'd Qty:** 8.00

**\*8\***

**Reference:**

**Cust Item ID:**

**Customer:**

**Approvals:** **Process Plan:**

Date:

Tooling:

Date:

Run Start

**\*NR1\***

**QC:**

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***

**Sequence ID/  
Work Center ID**

160  
**\*160\***

Powdercoat  
Powder Coating

**Operation  
Description**

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

Set Up/  
Run Hours

0.00

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

8x8 m/s 13/06/06

170  
**\*170\***

QC  
Quality Control

Memo

7:10  
0.00

START TIME: FINISH TIME: OVEN TEMPERATURE:

3200F

7:40

170

QC3- Inspect Part Finish

0.00

8x4 m/s 13/06/06

Memo

0.00

180

**\*180\***

Small Fab

Small Fab

0.00

6 φ FF 13-06-06

Memo

0.00

Assemble as per Dwg D3179

NOTE: Acceptable to  
OPEN UP  $\phi 0.242^{\circ}$  HOLES  
TO  $\phi 0.248$ - $0.250^{\circ}$   
FOR INSTALLATION OF D2372  
PINS.

QSI 042  
13.06.06

**Work Order ID 102091**

Thursday, May 23, 2013 3:29:44 PM

**\*102091\***

Page 4

Item ID: D3179-041

Revision ID: U/R

Item Name: Fwd Litter Tie Down

Start Date: 5/30/2013 Start Qty: 8.00

Accept

**\*N900040100\***

Setup

**\*NS1\***

Start

**\*NS2\***

Required Date: 5/30/2013 Req'd Qty: 8.00

**\*8\*****\*8\***

Reference:

Cust Item ID:

Customer:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***Sequence ID/  
Work Center ID

190

**\*190\***

QC

Quality Control

Operation  
Description

QC5- Inspect part completeness to step on W/O

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
StampDAS  
278  
13-67

6

200

**\*200\***

Packaging

Packaging

Identify as per dwg & Stock Location: ST221

0.00

0.00

6x

M.L. 13-06-6

8P

210

**\*210\***

QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

0.00

13/6/10 J

PLB-041

# Picklist Print

Thursday, May 23, 2013 3:29:42 PM

Page 1

Work Order ID: 102091

Parent Item: D3179-041

Parent Item Name: Fwd Litter Tie Down

Start Date: 5/30/2013

Required Date: 5/30/2013

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP A1 03.01.09 Added Acid etch end alodine RF  
 IPP Rev:B Added Powder Coat 07-07-04 JLM  
 IPP Rev:C 08-12-10 add part list DD verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

NAS1149D0332J

Washer

Purchased

No

100

Each

798.0000

3

24

FF

13-06-06

Location	Loc Qty	Loc Code
ST293	360	
<u>125268</u>	360	
ST294	438	
122973	68	
125044	370	

D2372

Quick Release

Manufactured

No

180

Each

31.0000

2

16

FF

13-06-06

Location	Loc Qty	Loc Code
GA	31	
<u>101076</u>	12	
86001	2	
97848	5	
99810	12	

D2444

Pip Pin Assembly

Manufactured

No

180

Each

25.0000

1

8

FF

13-06-06

Location	Loc Qty	Loc Code
ST010	25	
<u>101027</u>	10	
97238	1	
<u>98455</u>	5	
<u>99370</u>	4	
<u>99784</u>	5	

# Picklist Print

Thursday, May 23, 2013 3:29:43 PM

Page 2

Work Order ID: 102091

Parent Item: D3179-041

Parent Item Name: Fwd Litter Tie Down

Start Date: 5/30/2013

Required Date: 5/30/2013

Start Qty: 8.00

Required Qty: 8.00

D6201

"T" Extrusion

Manufactured

No

180

f

47.9646

1.0125

8.5263158

PD 13/05/29

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT028	47.96463153	
81421	4.61863153	
83987	20	
89645	3.346	
96808	20	

MS21042L3

Nut

Purchased

No

180

Each

3,403.0000

1 8

FF 13-06-06

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP001	3	
122141	3	
GA	18	
122452	18	
ST314	268	
117885	32	
119017	55	
119075	138	
123265	43	
ST506	3114	
123900	954	
124291	2160	

MS27039-1-13

Screw

Purchased

No

180

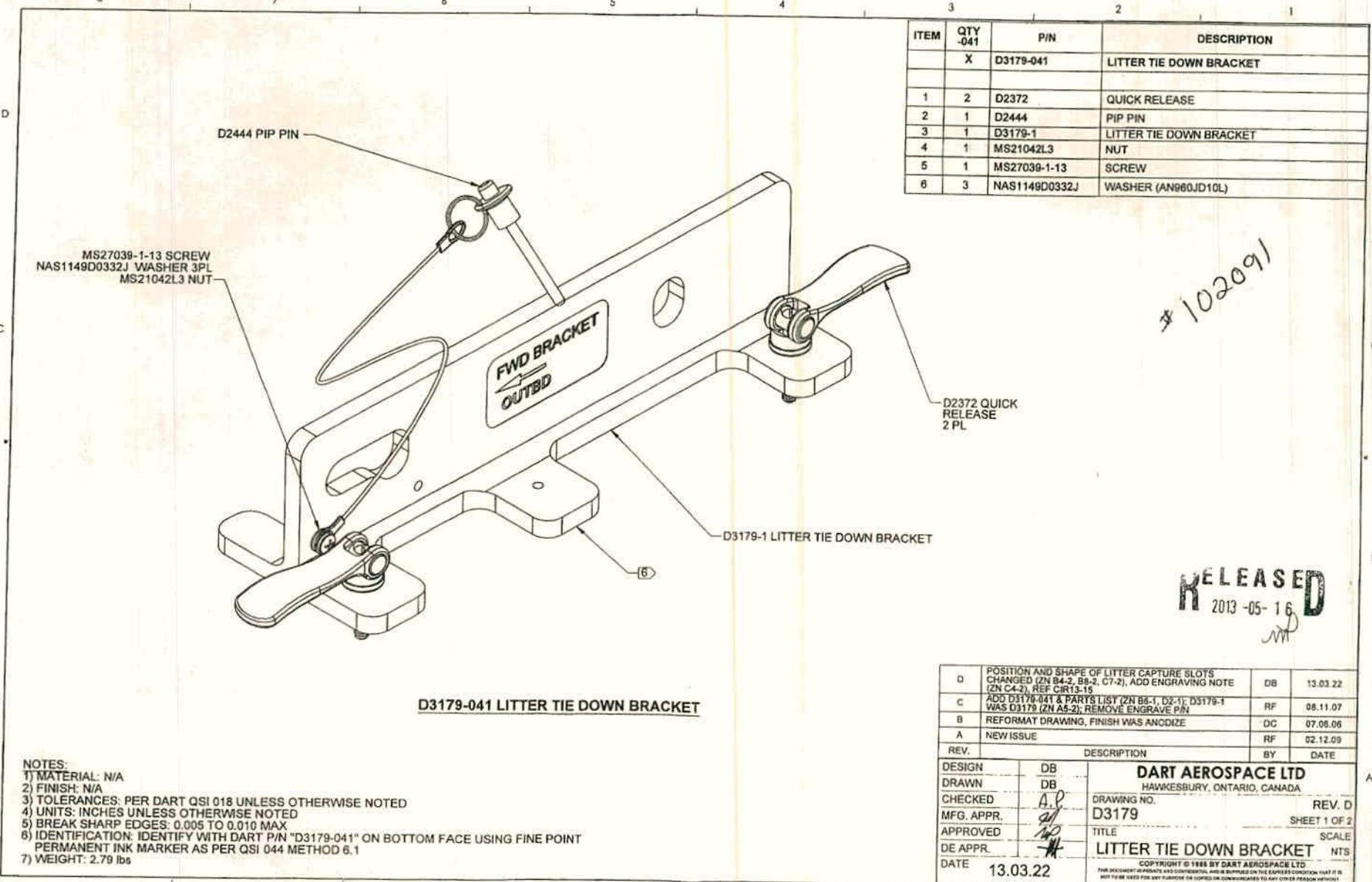
Each

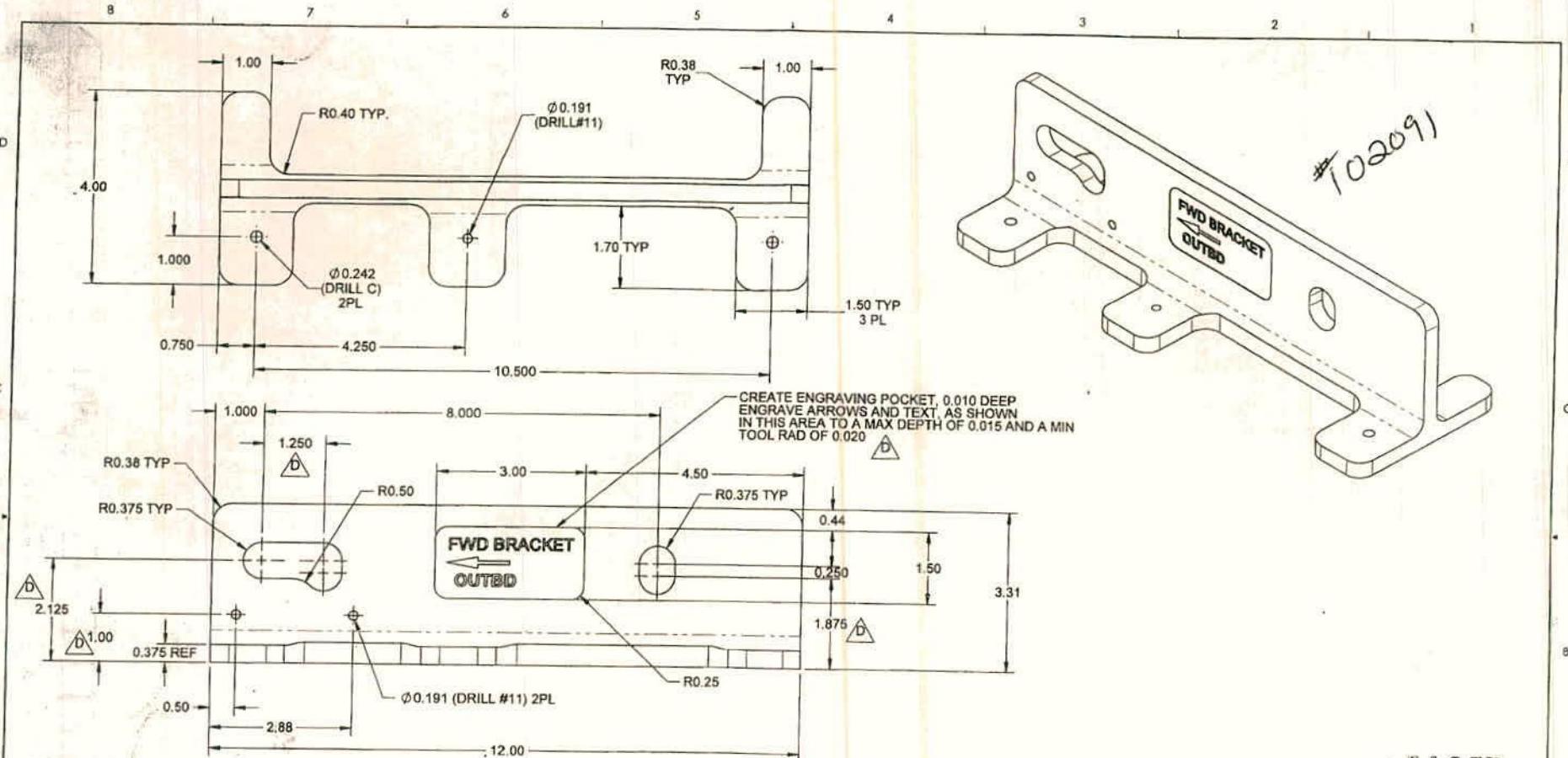
944.0000

1 8

FF F 13-06-06

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
GA	2	
119736	2	
ST304	42	
119736	42	
ST306	400	
125654	400	
ST506	500	
124326	500	





D3179-1 TIE DOWN BRACKET

A NOTES:

- 1) MATERIAL: MAKE FROM D8201-012 EXTRUSION (6061-T6/T6511 PER QQ-A-200/8)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT "WHITE" (4.3:5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.90 lbs

DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	DB	
CHECKED	A.P.	
MFG. APPR.	SJ	
APPROVED	MF	
DE APPR.	MF	
DATE	13.03.22	
DRAWING NO.	D3179	REV. D
TITLE	LITTER TIE DOWN BRACKET	SHEET 2 OF 2
SCALE	NTS	

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RELEASER  
2013-05-16

DART AEROSPACE LTD	Work Order:	102091
Description: Fwd litter tie down	Part Number:	3179-1
Inspection Dwg: D3179 Rev: D		Page 1 of 2

### FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.00	+/- .030	1.001	✓		vern	IT-4
.191	+ .005/- .001	.193	✓			
1.00	+/- .030	.997	✓			
1.50	+/- .030	1.499	✓			
1.70	+/- .030	1.699	✓		depth gauge	IT-6
10.500	+/- .010	10.500	✓		tape	IT-10
4.250	+/- .010	4.250	✓			
.750	+/- .010	.749	✓			
1.000	+/- .010	1.000	✓			
4.000	+/- .030	3.998	✓			
1.000	+/- .010	.999	✓			
8.000	+/- .010	8.000	✓			
3.00	+/- .030	2.990	✓			
4.50	+/- .030	4.52	✓			
R.375		.3725	✓			
.44	+/- .030	.456	✓			
1.90	+/- .030	1.470	✓			
.250	+/- .010	.244	✓			
3.31	+/- .030	3.315	✓			
1.875	+/- .010	1.868	✓			
11.00	+/- .030	11.000	✓			-
.242	+ .005/- .001	.244	✓			
2.48	+/- .070	2.473	✓			

Measured by: *CT 02*  
Date: *13-05-31*

Audited by: *04  
9-89*  
Date: *13.C.3*

Preliminary Approval:  
Date: *KJ*

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

*172*  
.2189

*10.04.15*

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	
<b>Description:</b>	<b>Part Number:</b>	
<b>Inspection Dwg:</b>	<b>Rev:</b>	Page 4 of 4 2 2

## FIRST ARTICLE INSPECTION CHECKLIST

Measured by:	IT 02	Audited by:	RD	Preliminary Approval:	
Date:	13-05-31	Date:	B.G.S	Date:	

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

10.06.15